

CENTRAL INTELLIGENCE AGENCY
INFORMATION REPORT

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COUNTRY East Germany

REPORT

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SUBJECT VEB Industrierwerke Ludwigsfelde:
 Production, Personnel, Technical
 Specifications

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REFERENCES

This is UNEVALUATED Information

THE SOURCE EVALUATIONS IN THIS REPORT ARE DEFINITIVE.
 THE APPRAISAL OF CONTENT IS TENTATIVE.
 (FOR KEY SEE REVERSE)

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Production of VEB Industrierwerke, Ludwigsfelde

1. The principal products of the plant and their destination (where known) are as follows:
 - a. Diesel Trolleys (Dieselameisen)
 The motors for these trolleys were supplied by VEB Phaenomen Kraftfahrzeug-Werk, Zittau, as of 19 February 1955.
 - b. D 2500 diesel engines (formerly KVD 25)
 Parts produced in the various shops are sent to Shop No. 9 to be assembled into small technical units.
 - c. Pitty motor scooters
 Motors are produced by VEB Motorradwerk, Zschopau. The first 90 machines were delivered to the HO (state-owned shops) on 14 February 1955.
 - d. Autocycle motors
 Parts are delivered to VEB Messgeraete- und Armaturenwerk "Karl Marx", Magdeburg, where they are assembled. Production will be continued only until the end of the second quarter of 1955.
 - e. "Jumo 205" engine parts
 Parts are delivered to VEB Rosslauer Schiffswerft.
 - f. Cylinder sleeves for aircraft engines
 These are exported directly to the USSR.

2. Total 1954 production figures for diesel trolleys and motor scooters were as follows:

	<u>Plan</u>	<u>Actual</u>
Diesel trolleys	500	392
Pitty motor scooters	5,500	125

Parts for an additional 625 motor scooters were 90% complete as of 1 January 1955.

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STATE	X	ARMY	X	NAVY	X	AIR	X	FBI		AEC		ORR	EV	X		
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3. Production of a number of other types of diesel engines is scheduled for 1955. These include:

S 2 DV 224
S 4 DV 224
S 6 DV 224
Grosse Kuestenfahrt
Kleine Kuestenfahrt

Preparatory work for the production of the first three types started in December 1954, in consultation with VEB-Schwermaschinenbau Karl Liebknecht, Magdeburg. As of 31 March 1955, production had not begun.

4. Personalities

4. The high percentage of production rejects in February 1955, which were not discovered until mid-March, caused the dismissal of the following leading personnel of the plant:

Bischoff	Labor Director
Richter	Commercial Director
Freitag	Head of Production
Bielke	Chief Bookkeeper
Chobrugk	Departmental Chief for "Cooperation"
Merker	Departmental Chief for Sales
Roske	Departmental Chief for Quality Control
Berger	Departmental Chief for Construction
Schebel	Departmental Chief for Technical Drawing Office

Further proceedings are pending.

5. The following persons were transferred to Pirna in December 1954:

Technical Director	Makella
Chief Technologist	Schott
Chief Dispatcher	Lahme

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INDUSTRIEWERK LUDWIGSEELDE - QUARTERLY REPORT 1.1 - 31.3.55

<u>Plan</u> <u>Position</u>	<u>Product</u>	<u>Design</u> <u>No</u>	<u>Shop</u> <u>Nos.</u>	<u>Price</u> <u>in DM</u>	<u>Production</u> <u>Planned</u> <u>Actual</u> <u>(in pieces)</u>
1	Diesel trolleys (DIESELARBEISE)		3 & 2	170	119
2	Splined shaft for ships' diesel motors D 2500 (complete)	ONK ZN 6086	7 & 8	2,900	3,000
3	Adjustable V-belt pulleys for D 2500	ONK ZN 6063	7	2,500	2,320
4	"PITTY" motor-scooters		3, 7, & 11	877	680
5.	<u>Auto-cycle motor parts</u> Large cog wheels Pinions Wrist pins Ring magnets		7	22,500	15,000
			No breakdown (see monthly reports)		
6.	Jumo engine cylinders and pistons (complete)	322,600-151: 1, 2, 3, 4	8	90	75
	Replacements		8	200	132
7.	Cylinder Sleeves for aero engines (for direct export to the USSR)	54.02-402 Soviet design No. 201.100- 2021 A	5, 7, 8 & 11	22,500	20,500
8.	<u>D.2500 Diesel engine parts</u> Repairs Production (See details in monthly reports)		9 7, 8, 9	250,000 DM 8,740	4,021
9.	Jumo engine pistons Type D. (complete)	322,600-130	9	730	714

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<u>Plan Position</u>	<u>Product</u>	<u>Design No</u>	<u>Shop Nos.</u>	<u>Price in DM</u>	<u>Production</u>	
					<u>Planned</u>	<u>Actual</u>
					<u>(in pieces)</u>	
10	<u>Jigs and Tooling up for:</u>					
	D 2500		11		417	367
	Junco		11		73	43
	Others		11		940	444
11	<u>Sub-Contracts</u>					
a)	Crankshafts	54.02-401	8,11		128	108
b)	Cylinder heads for D 2500	ZN 022110	9		1,200	1,140
c)	Splined shafts	OMV 30	8		3,000	2,500
d)	Bevel wheel shafts	SK 07.413	8		300	285
e)	Sliding nuts (SCHIEBE UTTER)	403-112.556	7		200	192
f)	Engine casings (GEHAUSE)	44/05 -IV	7		100	91
g)	Pre-welding flange (VORSCHWEISSFLANSCH)	250 DIN	7		40	40
h)	Crankshafts for experimental motor		8		2	2
i)	Others			125,000		102,000

Notes:-

- a) Plan Position 9 Junco engine pistons (complete). This includes:
- 1 Piston barrel with wrist pin bushing and wrist pin, and distance ring.
 - 3 Ball discs (Kugelscheiben)
 - 1 Ball pan (Kugelpfanne)
 - 1 Tie rod
 - 1 Piston plate (Kolbenplatte)
- b) Plan Position 11 Sub contracts were for the following factories:-
- a) The crankshafts were supplied to Ludwigsfelde for finishing by VEB Gelenkmurbelwellenfabrik Stadttilm in Thüringen. Design No. is similar to that of the Sleeves of Plan Position 7. After completion, they are delivered to a works in Johannistal.

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- b) ?
- c) ?
- d) VEB Schlepperwerk Brandenburg
- e) " "
- f) VEB Schumann & Co., Armaturen und Apparatebau,
LEIPZIG
- g) VEB Messgeräte und Armaturenwerk "Karl Marx"
Magdeburg.
- h) VEB Waggon-und Strassenbahnreparatur Berlin-
Johannistal.

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INDUSTRIEWERK LUDWIGSFELDE - NOVEMBER MONTHLY REPORT 1.11 - 30.11.54

<u>Plan Position</u>	<u>Product</u>	<u>Shop Nos.</u>	<u>Price in DME</u>	<u>Production</u>	
				<u>Planned (in pieces)</u>	<u>Actual</u>
1.	Diesel Trolleys	3 & 2		100	94
2.	Splined shafts for ships' diesel motors D 2500 (without sprocket)	3 & 2		1,000	832
	Sprockets	7		1,000	796
3.	Adjustable V-belt pulleys for D 2500	7		1,000	780
4.	"PITTY" Motor scooters	4		500	57
5.	<u>Auto-cycle motor parts</u>				
	Large cog-wheels	7		7,000	8,456
	Pinions	7		10,000	8,555
	Wrist pins	7		10,000	?
	Ring magnets	7		10,000	8,502
6.	Jumo engine cylinders and pistons (complete)	8		30	32
7.	Cylinder Sleeves for aero engines (for export to the USSR)	8		4,000	15,000
8.	<u>D 2500 Diesel engine parts</u>				
	Repairs	9	140,000 DM		266,000 DM
9.	Jumo engine pistons (complete)	9		240	252
10.	<u>Jigs and tooling up</u>				
	D 2500		25,000 DM		
	Jumo		10,000 DM		
	Cylinder sleeves for aero-engines		15,000 DM		
	Auto-cycle motors		6,000 DM		
	Diesel trolleys		8,000 DM		

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<u>Plan Position</u>	<u>Products</u>	<u>Shop Nos.</u>	<u>Price in DM</u>	<u>Production</u>	
				<u>Planned</u>	<u>Actual</u> (in pieces)
11	<u>Sub-Contracts</u>				
	Unspecified	6	33,000 DM		
		7	40,000 DM		
		8	65,000 DM		
		9	56,000 DM		
		11	<u>18,000 DM</u>		
			212,000 DM		254,000 DM
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12	Luggage carriers for auto-cycles or auto- scooters	3		300	100
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Notes

Plan position 11 (Sub-contracts) includes cylinder heads for PIONIER Tractor
motors for VES Schleppenwerk, Brandenburg.

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INDUSTRIELLES LUDWIGSFELDE - DECEMBER MONTHLY REPORT 1.12 - 31.12.54

<u>Plan Position</u>	<u>Product</u>	<u>Shop Nos</u>	<u>Price in DM</u>	<u>Production</u>	
				<u>Planned</u>	<u>Actual</u> (in pieces)
1	Diesel Trolleys	3 & 2		100	101
2	Splined shafts for D 2500 (complete)	3		700	433
3	Adjustable V-belt pulleys for D 2500	7		1,000	680
4	"PITTY" motor scooter	4		500	?
5	<u>Auto-cycle motor parts</u>				
	Large cog wheels	7		10,000	
	Pinions	7		10,000	
	Wrist pins	7		15,000	
	Ring magnets	7		5,000	
6	Jumo engine cylinders and pistons (complete)	8		30	30
7	Cylinder Sleeves for aero-engines (Export to USSR)	8 & 12		6,000	9,350
8	<u>D 2500 engine parts</u>				
	Repairs	9	300,000 DM		240,000 DM
9	Jumo engine pistons (complete)	9		360	351
10	<u>Jigs and Tooling up</u>				
	Unspecified		80,000 DM		48,000 DM
11	<u>Sub contracts</u>				
a)	Unspecified	6	30,000 DM		?
b)	Cylinder heads (boring)	7		800	?
c)	Unspecified	8	35,000 DM		?
d)	Cylinder heads (boring)	9	{		?
	Plug studs (assembly)		{ 75,000 DM	1,000	
	(ZAPFEN)				/2...

<u>Plan</u> <u>Position</u>	<u>Product</u>	<u>Shop Nos</u>	<u>Price in DM</u>	<u>Production</u> <u>Planned</u> <u>Actual</u> <u>(in pieces)</u>
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11 (Contd). e) Unspecified		11	3,000 DM	?
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Notes Plan position 7 (Sleeves). Total production was 11,350 pieces.
2000 of these however proved to be rejects.

Plan position 10

80% of this sum was scheduled for the production of jigs for
D 2500 production

Plan position 11 - b & d. Cylinder heads were for diesel engines
produced by VEB Karl Liebknecht, Magdeburg.

INDUSTRIALWERK LUDWIGSFELDE - JANUARY MONTHLY REPORT 1.1 - 31.1.55

<u>Plan Position</u>	<u>Product</u>	<u>Shop Nos</u>	<u>Price in DM</u>	<u>Production Planned</u>	<u>Actual</u> (in pieces)
1	Diesel Trolleys	3 & 2		50	23
2	Splined shaft for D 2500 (complete)	7 & 8		800	675
3	Adjustable V-belt pulleys	7		1,000	600
4	Motor scooter parts	3,7,11			
5	<u>Auto-cycle motor parts</u>				
	Large cog wheels	7		6,000	4,800
	Pinions	7		8,000	7,200
	Wrist pins	7		8,000	7,500
	Ring magnets	7		4,000	3,400
6	Juno engine cylinders and pistons (complete)	8		30	23
7	Cylinder sleeves for aero-engines (Export to USSR)	5,7,8,11		4,000	2,990
8	<u>D 2500 Diesel engines</u>				
	Repairs		180,000 DM		183,400 DM
9	Juno engine pistons Type D (complete)	9,11		250	240
10	<u>Jigs and tooling up</u>				
	D 2500	11	50,000 DM		40,000 DM
	Others	11	60,000 DM		35,000 DM
11	<u>Sub-contracts</u>				
a)	Crankshafts for experimental motor	3		2	2
b)	Cylinder heads D 2500	9		700	700
c)	Bevel wheel shafts	3		300	235
d)	Sliding sleeve	7		200	192
e)	Engine casings	7		100	91
f)	Pre-welding flange	7		40	40

INDUSTRIEWERK LUDWIGSFELDE - FEBRUARY MONTHLY REPORT 1.2 - 28.2.55

Plan Position	Product	Shop Nos	Price in DME	PRODUCTION	
				Planned	Actual
				(in pieces)	
1	Diesel Trolleys	3,2		54	56
2	Splined shaft D 2500 (complete)	7,8		1,500	1,525
3	Adjustable V-belt pulleys	7		1,000	1,700
4	"PITTY" motor scooters	3,7,11		257	280
5	<u>Auto-cycle motor parts</u>				
	Large cog wheels	7		10,000	10,200
	Pinions	7		10,000	7,800
	Wrist pins	7		10,000	7,500
	Ring magnets	7		10,000	4,600
6	Jumo engine cylinders and pistons (complete)	8		30	32
	Replacements	8		200	182
7	Cylinder Sleeves for aero engines	8,7,11		{ 10,000	300
	(Export to the USSR)	5			10,010
8	<u>D 2500 Diesel engine parts</u>				
	Production (see details below)	7,8,9,11		7,240	1,053
9	Jumo engine pistons Type D (complete)	9,11		240	240
10	<u>Jigs and Tooling up</u>				
	for:				
	D 2500	11		157	157
	Jumo	11		53	31
	Others	11		75	72
11	<u>Sub-contracts</u>				
a)	Crankshafts	11		28	10
b)	Cylinder heads	9		1,000	978
c)	Splined shafts	?		1,500	1,050

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NotesPlan position 7

Sleeves for export to the USSR.
 The quantity originally included in the monthly report was 17,513. 7,500 of these proved however to be rejects. A number of leading personalities in the works were dismissed as a result of this failure, which was first discovered in the middle of March.

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Plan position 8

Details of 1,053 engine parts for D 2500
 (Specifications where available)

a) Ball pieces (Kugelstück)	43	
b) Stoppers	20	
c) Covers	2	
d) Studs (Type 1)	8	
e) Thread sleeves (Gewindebuchsen) (Type 1)	20	
f) Distance rings	60	M St.50.11
g) Studs (Type 2)	60	M St.50.11
h) Connecting rods (Type 1)	20	M St.34 K
i) Stays	400	
j) Connecting rods (Type 2)	20	M.St.34.K
k) Thread sleeves (Type 2)	400	
	<u>1,053</u>	

Types 1 and 2 in all cases denote different design nos.

Plan Position 9Jumo cylinders

15 pieces were delivered to the Elbwerk ROSSLAU for testing before the scheduled date, on the orders of the Ministry of the Interior.

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INDUSTRIEWERK LUDWIGSFELDE - MARCH MONTHLY REPORT 1,3 - 31.3.55

<u>Plan Position</u>	<u>Product</u>	<u>Shop Nos.</u>	<u>Price in DM</u>	<u>Production</u>	
				<u>Planned</u>	<u>Actual</u>
				<u>(in pieces)</u>	
1	Diesel trolleys	3 & 2		75	40
2	Splined shaft for D 2500	7 & 8		600	300
3	Adjustable V-belt pulleys	7		500	20
4	"PITTY" motor scooters	3,7,11		620	400
5.	Auto-cycle motor parts	7		6,500	See note below
	Large cog wheels				
	Pinions				
	Wrist pins				
	Ring magnets				
6	Jump engine cylinders and pistons (complete)	8		30	30
7	Cylinder Sleeves for aero- engines (USSR export)	5		8,500	7,500
8	<u>D 2500 diesel engine parts</u>				
	Repairs:				
	Production:	7,8,9,11		1,500	2,968
	(see details below)				
9	Jump engine pistons (complete)				
	Type D	9		240	234
10	<u>Jigs and tooling up</u>				
	D 2500	11		50	24
	Jump	11		20	12
	Others	11		160	140
11	<u>Sub-contracts</u>				
a)	Crankshafts	8,11		100	98
b)	Cylinder heads for D 2500	9		200	162
c)	Splined shafts	8		1,500	1,450
d)	Others		75,000 DM		67,000 DM

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NotesPlan position 5 Auto-cycle motors.

No fulfilment figures are given, since it was discovered in mid-March that practically the whole of the February production was reject. Production in March therefore consisted solely of replacement, of the rejects produced the previous month.

Plan position 7 Sleeves for export to the USSR.

The 7,500 pieces produced merely replaced the rejected sleeves produced in February.

Plan position 8 Details of 2,968 engine parts for D 2500 (Specifications where available).

a)	Serrated nuts	406	MC 60
b)	Thread sleeves	8	
c)	Distance rings	61	
d)	Ball pieces	43	M.G H38
e)	Castle nuts	270	M.St.50.11
f)	Retaining nuts (Stutznutter)	80	
g)	Adaptors (Einsatzunterteil)	400	
h)	Hubs	46	
i)	Stays	400	
j)	Studs	20	
k)	Bearing casings	5	
l)	Shaft bearings	20	
m)	Distance sleeves	20	
n)	Discs	40	
o)	Lock washers	40	
p)	Sleeves	20	
q)	Bearing sleeves	20	
r)	Screw rings	200	
s)	Thread sleeves	200	
t)	Ring stays	200	
u)	Clutch sleeves	8	
v)	Casings	21	
w)	Main connecting discs	200	
x)	Secondary " "	100	
y)	Fitting screws	40	M 37 Mn.Si.5
z)	Bearing sleeves	20	
a)	Tapers	80	

 2,968


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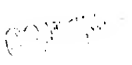

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 COMMENTS:

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1. The degree of disorganization and the high percentage of rejects within the factory made it particularly difficult to obtain any accurate picture of actual production. Cross-checking between the Production card index of the factory, and the factory's own monthly and quarterly reports has, we believe, produced as true an account as possible.

2. The difference of 25 in the actual production figures for Jano engine cylinders (Plan position 6) between the quarterly and monthly reports is probably due to the discovery of further reports is probably due to the discovery of further rejects.

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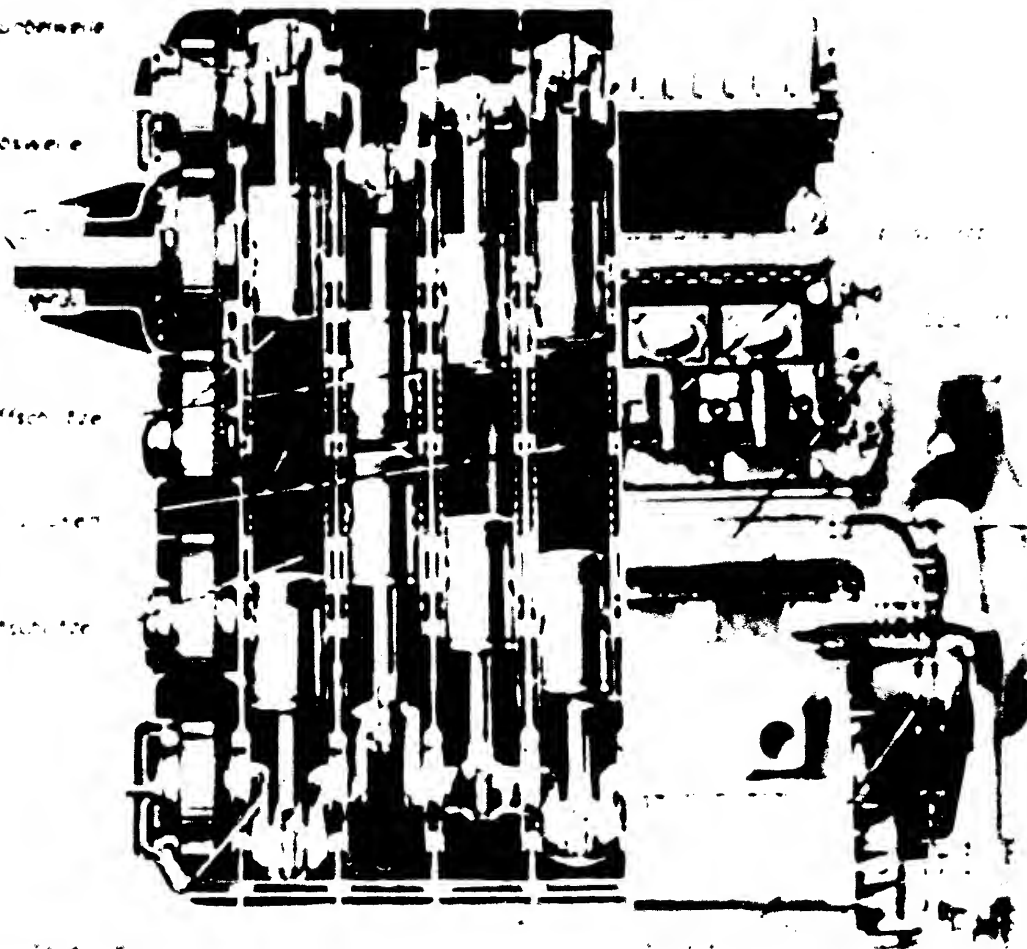
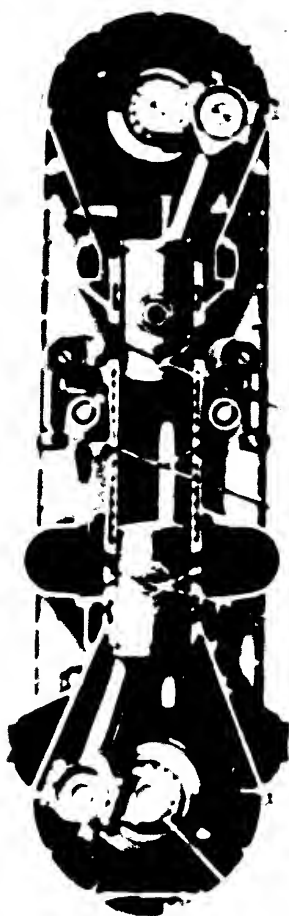
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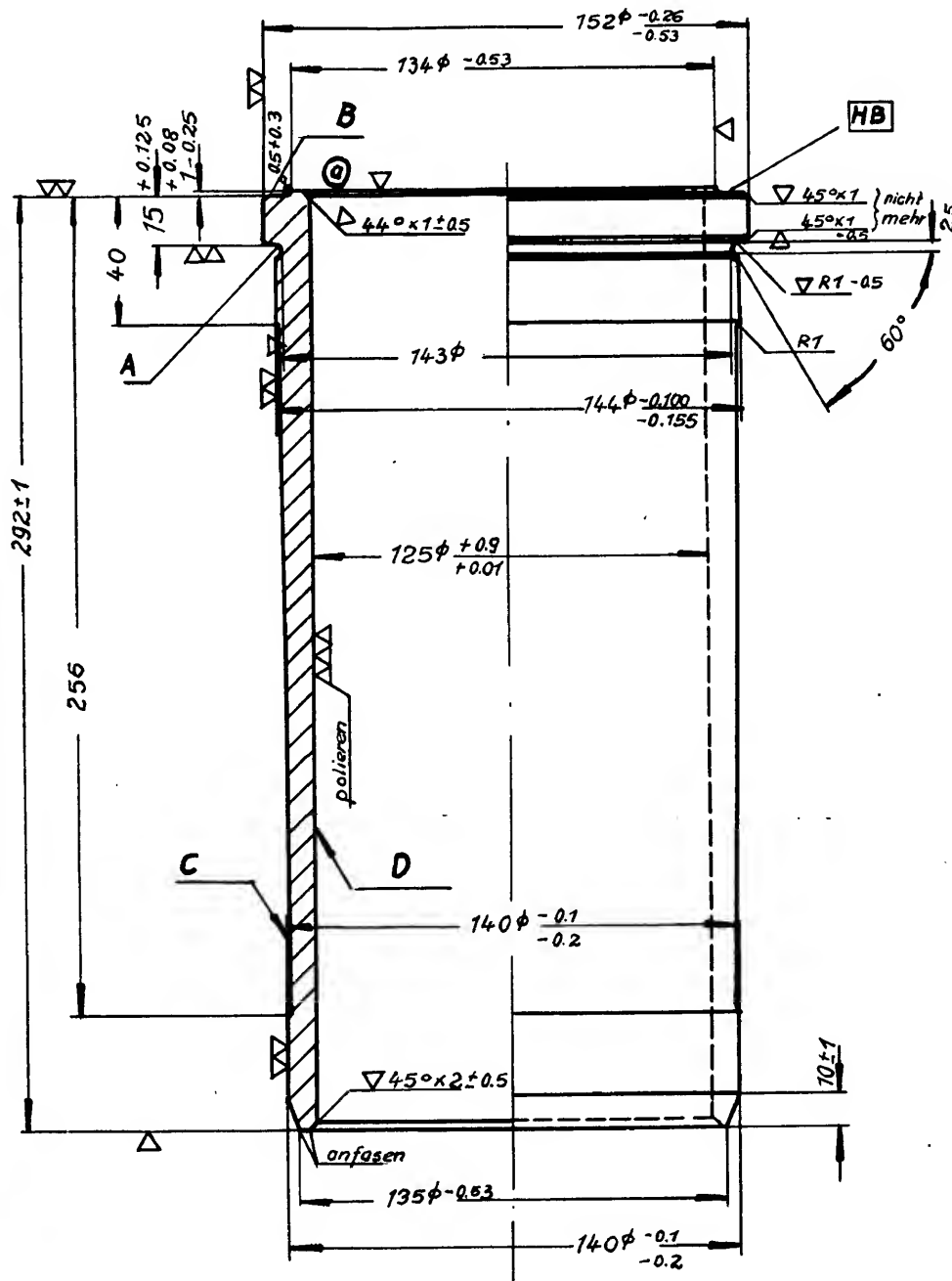
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